

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009925**Date Inspected:** 16-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Yin Xin, Pen Guo.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, East Tower, Lift 4, Fit Lugs.

FCAW welding of weld joint ESTL4-1C/L-7, 80, 8, 79; located on Bay10, East Tower, Lift 4. Welders are identified as 202821, 048810; ZPMC Quality Control Inspector (QC) is identified as Pen Guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-T-2133, 2) WPS-B-T-4133.

Bay 10, North tower, Corner Angle Plate.

SMAW Repair welding of weld joint ND1-A5012-22-1B (WRR # T-WR2473); located on Bay 10, North tower. Welders are identified as 040333; ZPMC Quality Control Inspector (QC) is identified as Chen Yin Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-FCM-Repair.

Bay 10, North tower, Corner Angle Plate.

SMAW Repair welding of weld joint ND1-A5012-13-1B (WRR # T-WR2484); located on Bay 10, North tower. Welders are identified as 050289; ZPMC Quality Control Inspector (QC) is identified as Chen Yin Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

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WPS-485-SMAW-2G(2F)-FCM-Repair.

Bay 11, West Shaft, Lift 3, Skin E (Temporary Attachment Area near Corner Seam A/E).

During random visual inspection at West Shaft, Lift 3, Skin E (Temporary Attachment Area near Corner Seam A/E) this Caltrans Quality Assurance (QA) Inspector observed "Crack Like" indications Transverse to the Removed weld at the Temporary attachment Weld area. The indications were shown to ZPMC and ABF QC Inspectors. ZPMC later confirmed these indications by Magnetic Particle Testing. This Caltrans Quality Assurance (QA) Inspector written Incident Report on same date.

This Caltrans Quality Assurance (QA) Inspector observed Crack Like Indications on the same area on date 10-15-09 & also written Incident Report on same date. ZPMC already completed Magnetic Particle Testing on the above mentioned area.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar, Amit	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
